



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW6205G13231-3G

Job Sheet 173115



Part No: RBW6205G13231-3G

Job Qty: 3 ea

Part Name: Arm Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/26/18

Job Tracking No:

Due Date: 3/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6205G13231-3G REV 1 IPP REV A 18.02.16 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea	3/16/18	3/16/18	0.00	0.00	Start Up Container		
100	Purchasing	3 pcs	3/16/18	3/16/18	0.00	0.00	Purchasing		ma 18/05/01
110	Packaging	3 pcs	3/16/18	3/16/18	0.00	0.00	Packaging2		ma 18/05/01
120	QC	3 pcs	3/16/18	3/16/18	0.00	0.00	QC6		2.3
130	Packaging	3 pcs	3/16/18	3/16/18	0.00	0.00	Packaging3		
140	QC21-SA	3 Ea	3/16/18	3/16/18	0.00	0.00	QC21		MAY 02 2018

Part Op 100 - 1- Issue P/O to Arrow Tech Machine Works P/O# 039145 2- Manufacture RBW6205G13231-3G as per Descriptions: DWG 3- Certificate of conformity is required

FEB 28 2018

MA 21

MA 03 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6205G13231-3GP	Arm Assembly	3 (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBW6205G13231-3GP	3	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

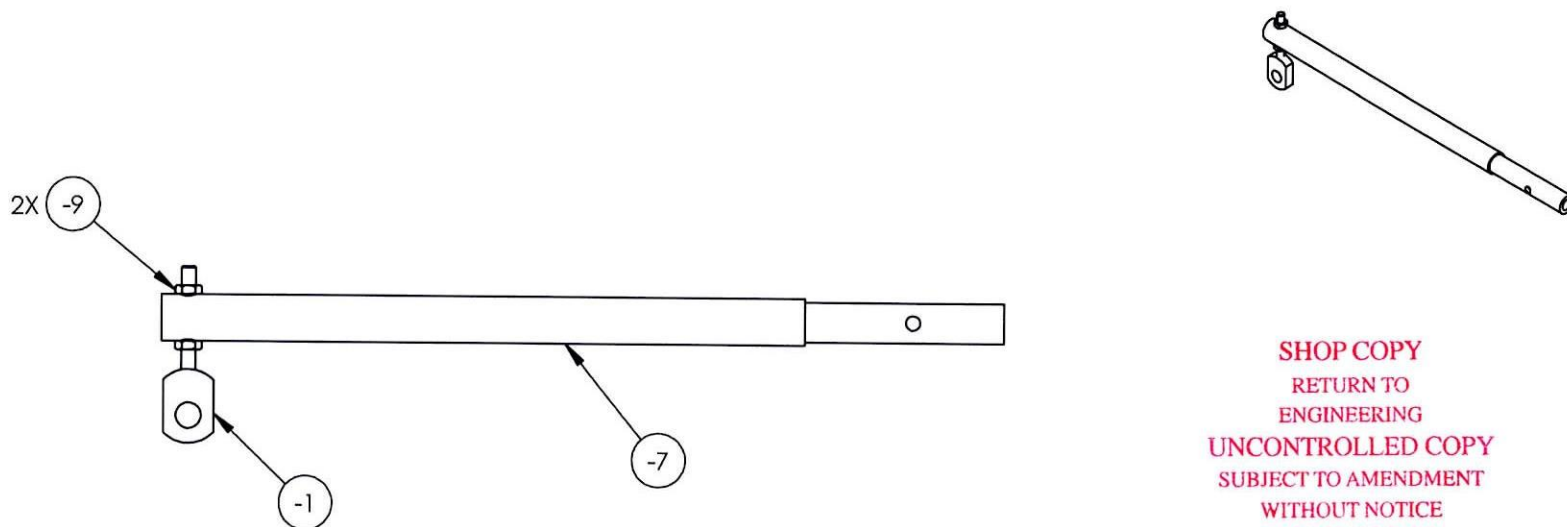
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐									
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																									
Description Work Order Deviation			Disposition																										
			Completed By																										
			Lead hand / Supervisor Approval Verification																										
			QC / QA Coordinator Approval																										
Root Cause <table style="width:100%;"> <tr><td>Environment ☐</td><td>No Re-verification ☐</td></tr> <tr><td>Design ☐</td><td>Operator ☐</td></tr> <tr><td>Doc/Data ☐</td><td>Offset/Setup ☐</td></tr> <tr><td>Equip/Tooling ☐</td><td>Supplier ☐</td></tr> <tr><td>Handling/Pre ☐</td><td>Training ☐</td></tr> <tr><td>Material ☐</td><td>Use for Testing ☐</td></tr> <tr><td>Internal Transport ☐</td><td>Poor Information ☐</td></tr> <tr><td>Tribal Knowledge ☐</td><td>Rushing ☐</td></tr> <tr><td>LOA ☐</td><td>Product Improvement ☐</td></tr> <tr><td>Substation ☐</td><td>Process Improvement ☐</td></tr> <tr><td>Past Expiry Date ☐</td><td>Manufacturing Process ☐</td></tr> <tr><td>Misidentified ☐</td><td>Past Due ☐</td></tr> </table>			Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 813 632-6200 Email: sales@dartaero.com www.dartaerospace.com Date: 05/01/18 Container No: S067410 Part: RBW6205G13231-3G Job No: 173115 Serial No/Batch: S067410 Revision: 1 Inspector: Drill Holes ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
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OTHER : _____																													

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		-1 DELETED ENGRAVE NOTE. -3 ADDED ENGRAVE NOTE. -7 ADDED ENGRAVE NOTE. -9 CH'D WAS 5/16-18 #93839A030 IS 5/16-24 UNF #93839A810.	1/19/2011	RJC	RW
B		-3 CH'D ENGRAVE NOTE WAS RBW6205G13451 IS RBW6205G13231-3G.	4/15/2013	CFS	RW
1	15-0152	-1 CH'D QTY WAS 3 IS 1, CH'D WELD WAS SILVER SOLDER IS TIG. CH'D MATERIAL CALL OUT WAS 1018 IS 1018/1020. -7 CH'D DIM WAS Ø.500 IS Ø.50.	7/1/2015	RJC	JAG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 173115 MJS
1802-26

NOTES:

1. REF. AGUSTA T/N: 3G6205G13231-3G.
2. PART OF KITS RBW6205G11231-3G AND RBW6205G13831-3G.



TITLE		ARM ASSEMBLY	
DWG NO.		RBW6205G13231-3G	
REV		1	
MATL	DRAWN BY: CLOUGH		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED <i>D Weil</i>	
.XXX ± .005	FRACTIONS ± 1/8	HEAT TREAT	
.XX ± .01	ANGLES ± 5°	FINISH	
.X ± .1	SPEC		
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		USED ON MODEL	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		AGUSTA	
SCALE	1:4	DATE	4/30/2010
		SHEET 1 OF 5	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	ADJUSTER WELDMENT			2
	1		-3		LINK	1018/1020		3
	1		-5		STUD	STEEL	5/16-24 (MCMASTER-CARR #98791A030) MODIFIED	4
			-7	1	TUBE	6061		5
		B/O	-9	2	THIN HEX NUT	STEEL	5-16-24 UNF (MCMASTER-CARR #93839A810)	1
ASSY #	ASSY -1							

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
FOR THE USE OF THE QUALITY ASSURANCE DEPARTMENT TO RECORD THE NON-CONFORMANCE OF A WORK ORDER AND TO TRACK THE CORRECTIVE ACTION TAKEN TO RESOLVE THE ISSUE. PLEASE COMPLETE THIS FORM AND SUBMIT TO THE QUALITY ASSURANCE DEPARTMENT FOR REVIEW AND APPROVAL. DATE: _____ BY: _____				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO039145

Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

PO No: PO039145
PO Date: 2/28/18
Due Date: 4/30/18
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Phone:

E-MAILED
MAR 12 2018

Ship To:

Pymt Terms: Net 30
Freight Terms:
Special Comments:

Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	RBW6205G12731-3GP			Upper Plate Assembly As Per Dwg RBW6205G12731-3G Rev. 3	Firmed	4/30/18	1 Ea	0 Ea	1 Ea	\$2,595.37/Ea	\$2,595.37
Line Item Note job# 173112											
2	RBW6205G13151-3GP			Lower Plate As Per Dwg RBW6205G13151-3G Rev. A	Firmed	4/30/18	1 Ea	0 Ea	1 Ea	\$718.91/Ea	\$718.91
Line Item Note job#173113											
3	RBW6205G13231-3GP			Arm Assembly As Per Dwg RBW6205G13231-3G Rev. 1	Firmed	4/30/18	3 Ea	0 Ea	3 Ea	\$413.50/Ea	\$1,240.50
Line Item Note job# 173115											
4	RBW6205G13531-3GP			Screw Assembly As per Dwg RBW6205G13531-3G	Firmed	4/30/18	3 Ea	0 Ea	3 Ea	\$315.70/Ea	\$947.10
Line Item Note job# 173116											
5	RBW6205G11451-3GP			Clamp As Per Dwg RBW6205G11451-3G Rev. 1	Firmed	4/30/18	8 Ea	0 Ea	8 Ea	\$83.64/Ea	\$669.12
Line Item Note job# 173120											
										Grand Total:	\$6,171.00

Order Notes

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No:039145

Dated: 04/27/2018

Our Order / Job No: 30AWT

Order Qty: 3

Part Name: ARM ASSEMBLY

Part Number: RBW6205G13231-3G

Lot Size: N/A

Ship Date:04/27/2018

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RBW6205G13231

Rev: 1

Material Size and Type: -3/1018 STEEL; -7/6061 ALUM.

Material Specifications: STEEL: ASTM A108, ASTM A29; ALUM.: ASTM B221

Heat Treatment: N/A

Plating/Finish: CLEAR ANODIZE: MIL-A-8625F, TYPE II, CLASS I; ZINC PLATE: ASTM B633 TYPE 1, SC2

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 04/27/18

Signed: _____

EP
MAY 07 2018

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29751 E. Enid Rd. Unit C Eugene, Oregon 97402
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www.atechmachineworks.com